

Work Order ID 62064

Wednesday, September 15, 2010 2:52:18 PM

Page 1

Item ID: D3629-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 9/15/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3629

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3629

☐ Dwg Rev: A

☐ Prog Rev: A

☐ 2-

Deburr if necessary

10-9-21

8

304 . 063

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-9-21

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

10/10/21

XS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Bend as per dwg D3629-2-Tumble								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Identify as per dwg & Stock Location: <u>247</u>	0.00							
Packaging	Memo	0.00							
Packaging									

SO 10/09/22

8/10/27

② B10-2-27 ⑧

②

② 8/9/27 ⑧

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Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 9/15/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CL10/9/28

10/09/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 15, 2010 2:52:22 PM

Page 1

Work Order ID: 62064

Parent Item: D3629-1

Parent Item Name: Bracket





Start Date: 9/15/2010

Required Date: 9/22/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-24 cc Verified By:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	14.1400	0.075	0.473684	6		
304/316 Sheet .063												1310-9-21	

Location

Loc Qty

Loc Code

MAT20

14.14

115440

14.14

115688

115688

8

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Dart Aerospace Ltd

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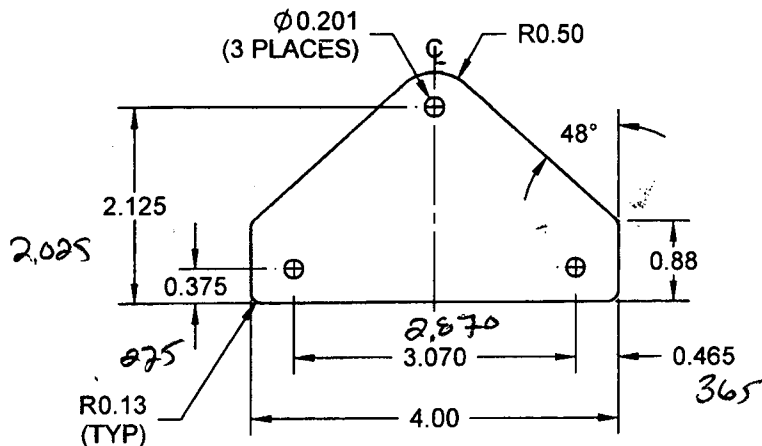
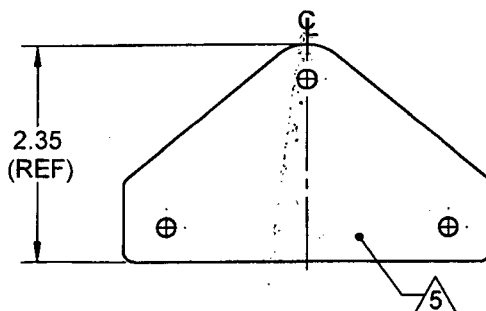
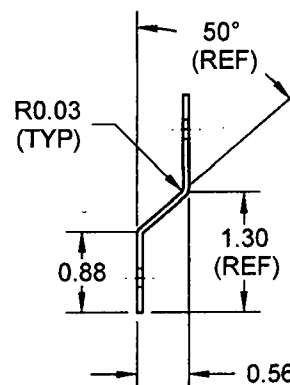
NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3629	REV. A SHEET 1 OF 1
DATE 07.05.10		TITLE BRACKET	SCALE 1:2
REV A	DATE 07.05.10	DESCRIPTION NEW ISSUE	

RELEASED07.07.11 *PH*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *42064*
PH 9-15

**1 D3629-1F BRACKET FLAT PATTERN****D3629-1 BRACKET
(MAKE FROM D3629-1F)****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.063 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) IDENTIFY WITH DART P/N "D3629-1" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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